



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-633-011
Job Sheet 182598



Part No: D205-633-011

Job Qty: 2 ea

Part Name: Heli-Access-Step™ - High Gear, Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/28/18

Job Tracking No:

Due Date: 10/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 17 IPP Rev:F 02.07.11 Reformat; Removed D3010 RF

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	10/9/18	10/9/18	0.00	0.00	Start Up Stores/Pkg-1		SEP 17 2018
110	Packaging	2 pcs	10/9/18	10/9/18	0.00	0.00	Packaging1-2		SEP 20 2018
120	QC	2 pcs	10/9/18	10/9/18	0.00	0.00	QC4		SEP 21 2018
130	Packaging	2 pcs	10/9/18	10/9/18	0.00	0.00	Packaging3-1		SEP 21 2018
135	DC	2 pcs	10/9/18	10/9/18	0.00	0.00	DC		SEP 21 2018
140	QC21-FG	2 Ea	10/9/18	10/9/18	0.00	0.00	QC21		SEP 21 2018

Part Op 130 - Identify and pack for shipping as per PPP D205-633-011 Location:FG082
Descriptions: 135 - Photocopy bluefile & type labels per PPP205-633-011 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN4-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5094583
AN4-5A	Bolt	4 Ea (2 ea)	90-Start up Operation	5089315
AN4-6A	Bolt	4 Ea (2 ea)	90-Start up Operation	5089455
AN4-7A	Bolt	4 Ea (2 ea)	90-Start up Operation	5087520
AN5-14A	Bolt	2 Ea (1 ea)	90-Start up Operation	5086344
AN5-6A	Bolt	2 Ea (1 ea)	90-Start up Operation	5102257
D2021-101	Eyebolt	2 Ea (1 ea)	90-Start up Operation	5091964
D2022-101	Spacer B	4 Ea (2 ea)	90-Start up Operation	5106652
D2022-103	Spacer B	4 Ea (2 ea)	90-Start up Operation	5109846
D2562-001	Strut 19.68"	2 Ea (1 ea)	90-Start up Operation	5091884x6, 5104752 x1
D2565-101	Strut	2 Ea (1 ea)	90-Start up Operation	5109725
D2565-103	Strut	2 Ea (1 ea)	90-Start up Operation	5109427
D2565-105	Strut	2 Ea (1 ea)	90-Start up Operation	5107448
D2565-107	Strut	2 Ea (1 ea)	90-Start up Operation	5092248x1
D2565-109	Strut	2 Ea (1 ea)	90-Start up Operation	5009531
D2565-111	Strut	2 Ea (1 ea)	90-Start up Operation	5111226
MS21042L4	Nut	16 Ea (8 ea)	90-Start up Operation	5094594
MS21042L5	Nut	4 Ea (2 ea)	90-Start up Operation	5083541
NAS1149D0463J	Washer	30 Ea (15 ea)	90-Start up Operation	5089299
NAS1149D0563J	Washer	8 Ea (4 ea)	90-Start up Operation	5095773
D2563	Step Weldment Assembly	2 Ea (1 ea)	110-Packaging	5103067

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐															
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Date: _____ Order #: _____ Order Deviation _____		QTY Effective : _____ Disposition _____				MRB (QSI042) Approval _____ Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____																																	
DART Aerospace Ltd. 1270 Aberdeen Street Markham, ON M6A 1K7 CANADA TEL.: 1 613 632-6200 Email: sales@dartaero.com www.dartaerospace.com Container No: S110753 Part: D205-633-011 Job No: 182598 Serial No/ Batch: S110753 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH96-57 Issue Bar FA-676 SR00592NY 03/08/01, FAA STI																																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		e/Forced ☐ bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%;">Temperature/Cure ☐</td> <td style="width:33%;">Power Loss/Surge ☐</td> <td style="width:33%;">Positioned Wrong ☐</td> </tr> <tr> <td>Set-up ☐</td> <td>Folio/Program ☐</td> <td>Outside Dimensions ☐</td> </tr> <tr> <td>BOM/Route ☐</td> <td>Grain ☐</td> <td>Over/Under tolerance ☐</td> </tr> <tr> <td>Broken/Damage/Defect ☐</td> <td>Weld ☐</td> <td>Part Incorrect ☐</td> </tr> <tr> <td>Inspection Incomplete/Unqualified ☐</td> <td>Wrong Stock Pulled ☐</td> <td>Part Lost/Missing ☐</td> </tr> <tr> <td>Contamination ☐</td> <td>Out of Sequence ☐</td> <td>Part Moved ☐</td> </tr> <tr> <td>Countersink ☐</td> <td>Off-set ☐</td> <td>Drawing ☐</td> </tr> <tr> <td>Cut Too Short ☐</td> <td>Mislabeled ☐</td> <td>Finish ☐</td> </tr> <tr> <td>Instructions Incomplete/Unclear ☐</td> <td>Fit/Function ☐</td> <td>Misread ☐</td> </tr> <tr> <td>Drill Holes ☐</td> <td>Misaligned/off center ☐</td> <td>Turning Sequence ☐</td> </tr> </table>				Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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OTHER : _____																																							

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN4-14A	2	297	0
	AN4-5A	4	215	0
	AN4-6A	4	1,312	0
	AN4-7A	4	76	0
	AN5-14A	2	70	0
	AN5-6A	2	98	0
	D2021-101	2	28	0
	D2022-101	4	3	0
	D2022-103	4	1	0
	D2562-001	2	7	0
	D2565-101	2	1	0
	D2565-103	2	1	0
	D2565-105	2	1	0
	D2565-107	2	3	0
	D2565-109	2	1	0
	D2565-111	2	2	0
	MS21042L4	16	5,260	0
	MS21042L5	4	1,054	0
	NAS1149D0463J	30	9,157	0
	NAS1149D0563J	8	1,980	0
	D2563	2	4	0
110-Packaging				

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

5.0 PARTS LISTS

REFERENCE ONLY

5.1 D205-633-011/-013/-015/-017 Heli-Access Step

QTY -011	QTY -013	QTY -015	QTY -017	Part Number	Description
X				D205-633-011	Heli-Access-Step™, High Gear
	X			D205-633-013	Heli-Access-Step™, Extended High Gear (31")
		X		D205-633-015	Heli-Access-Step™, Extended High Gear (39")
			X	D205-633-017	Heli-Access-Step™, Standard Low Gear
1			1	D2021-101	EYEBOLT
2	2	2	2	D2022-101	SPACER
2	2	2	2	D2022-103	SPACER
1				D2562-001	STRUT
		1		D2562-005	STRUT
			1	D2562-007	STRUT
	1			D2562-013	STRUT
1	1	1	1	D2563	WELDMENT ASSEMBLY
1				D2565-101	STRUT
1				D2565-103	STRUT
1				D2565-105	STRUT
1				D2565-107	STRUT
1				D2565-109	STRUT
1				D2565-111	STRUT
	1			D2565-201	STRUT
	1			D2565-203	STRUT
	1			D2565-205	STRUT
	1			D2565-207	STRUT
	1			D2565-209	STRUT
	1			D2565-211	STRUT
		1		D2565-301	STRUT
		1		D2565-303	STRUT
		1		D2565-305	STRUT
		1		D2565-307	STRUT
		1		D2565-309	STRUT
			1	D2565-401	STRUT
			1	D2565-403	STRUT
			1	D2565-405	STRUT
			1	D2565-407	STRUT
			1	D2565-409	STRUT
			1	D2565-411	STRUT
		1		D3165-1	SUPPORT ARM
	1	1		AN44-7A	EYEBOLT
2	1	1	2	AN4-5A	BOLT
2	3	3	2	AN4-6A	BOLT
2	2	2	2	AN4-7A	BOLT
1	1	1	1	AN4-14A	BOLT
	1	1		AN4-10A	BOLT
1			1	AN5-6A	BOLT
1	1	1	1	AN5-14A	BOLT
15	16	16	15	AN960JD416	WASHER
4	3	3	4	AN960JD516	WASHER
8	8	8	8	MS21042L4	NUT (or MS21042-4)
2	2	2	2	MS21042L5	NUT (or MS21042-5)

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Revision: C
 Date: 13.12.13

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PAGE 1 OF 1

Description: HELI-ACCESS STEP, HIGH GEAR / STANDARD LOW GEAR

H:\Forms\Engineer\Approved Eng Online\CHGREC revB